

Kit Components

Description.....	Part Number	Qty
Seat Rotation Stop	057-0578-00	1
Template	050-5602-00	1
Screw (5/16 - 18 x 7/8")	040-0312-08	1
Screw (#10-24 x 1/4")	040-0010-21	2
"F" size drill bit	505-747564	1

A. Removing Table Top

- (1) Raise back section all the way up, and lower base section all the way down.
- (2) Unplug chair power cord from outlet.
- (3) Remove four screws (1, Figure 1) and headrest assembly (2) from back casting (3).
- (4) If chair has optional exam light, remove four screws (4) and light (5) from bracket (6).

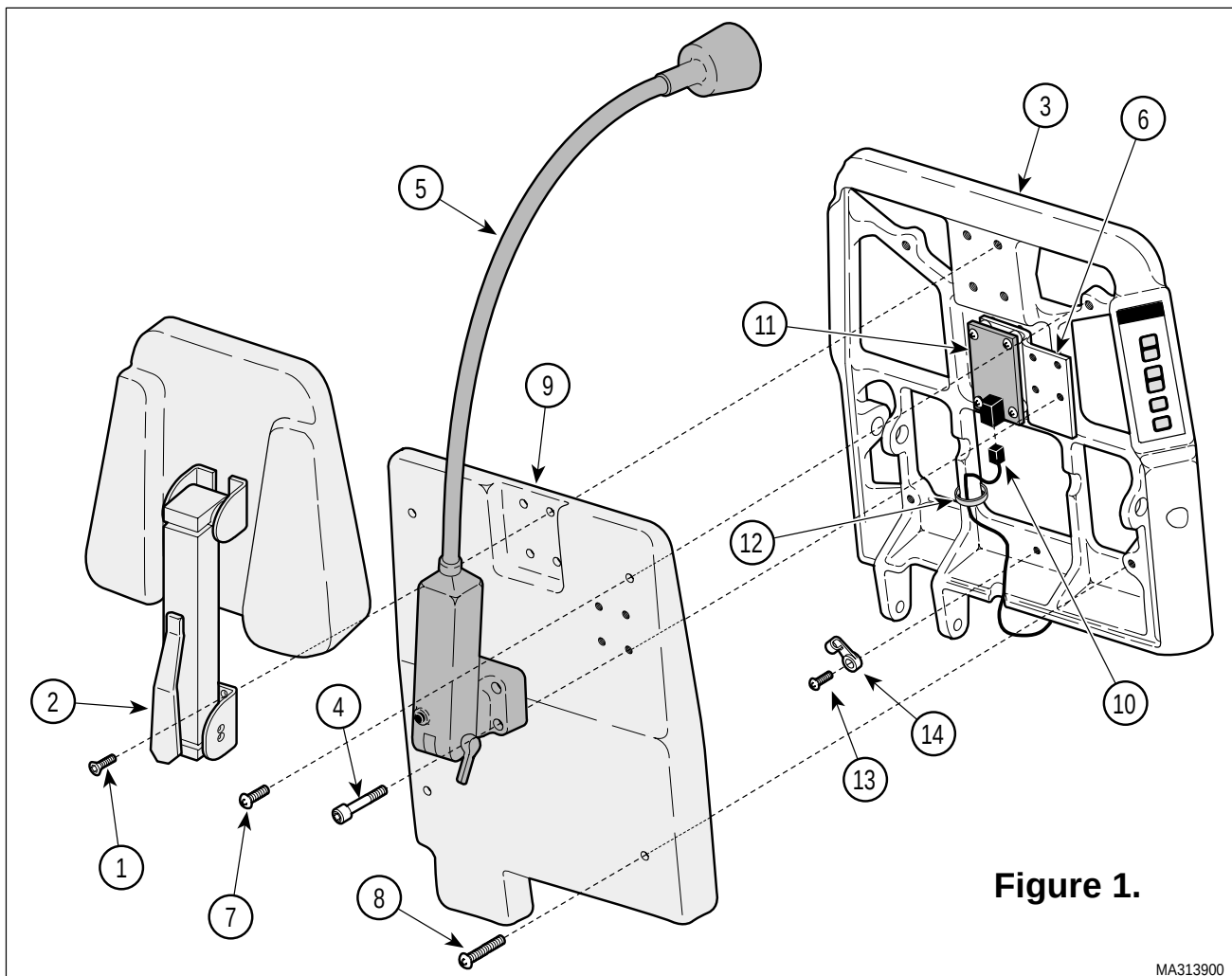
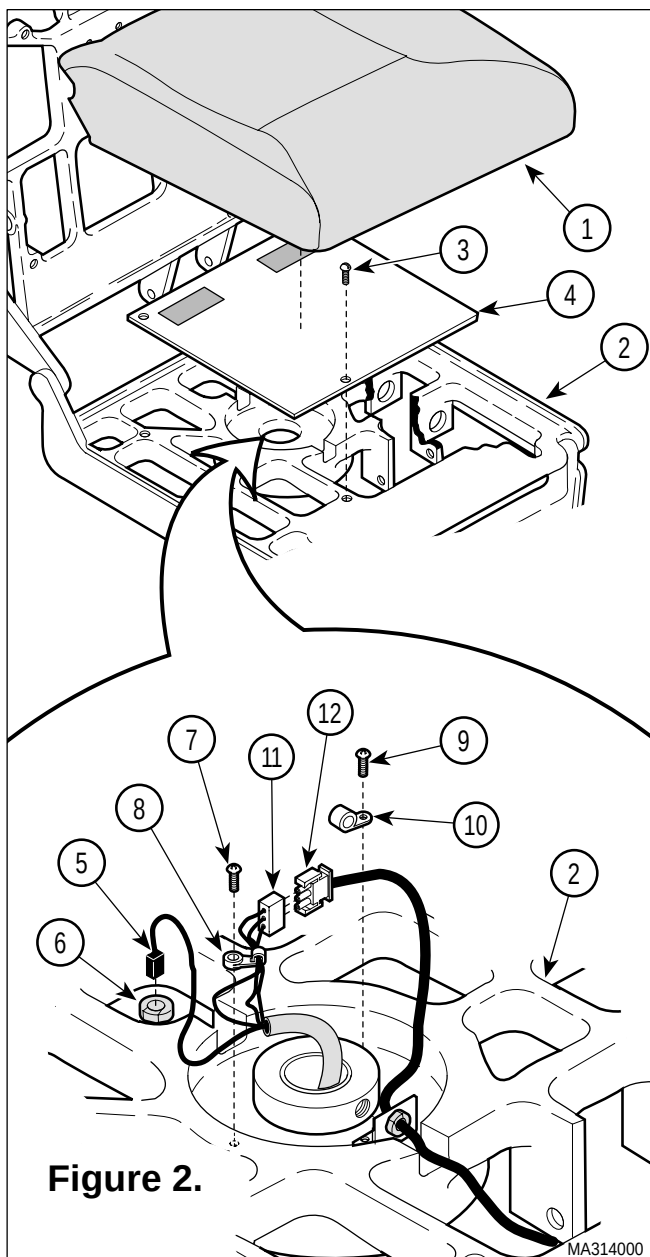


Figure 1.

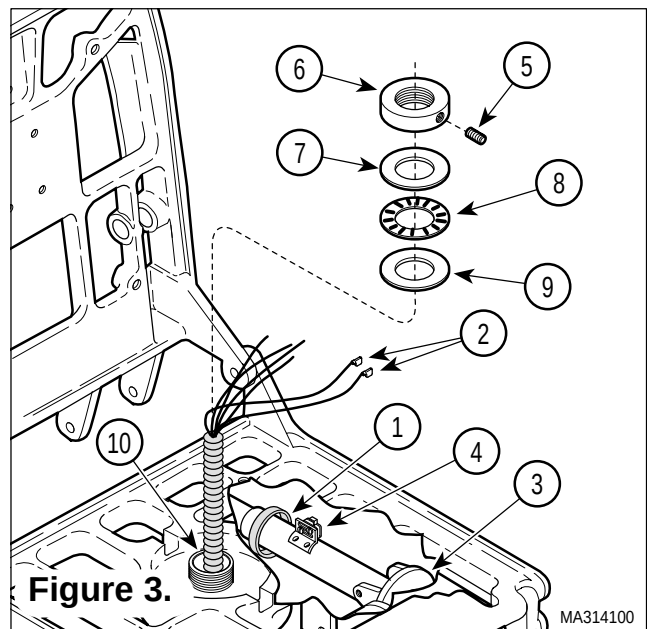
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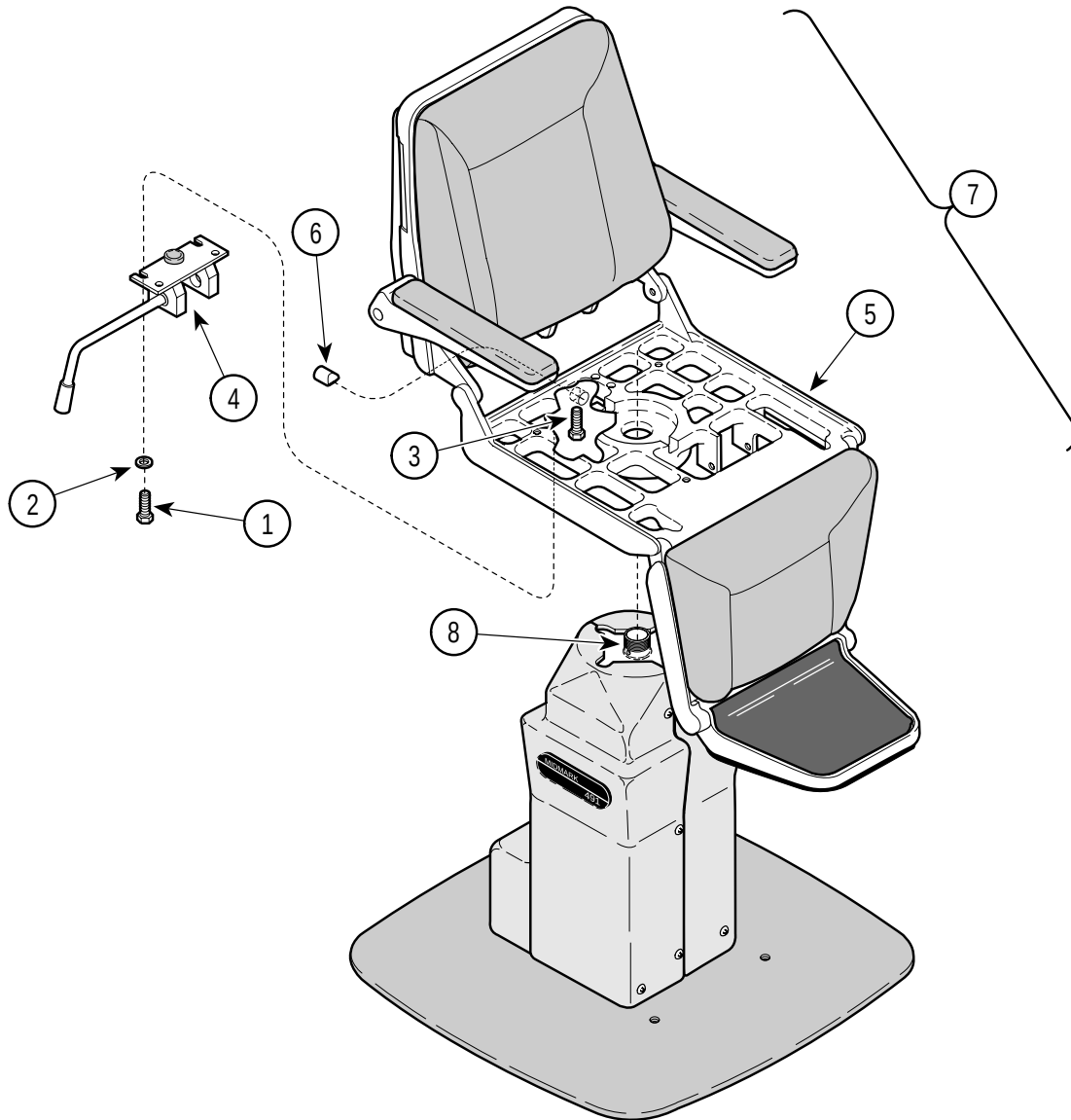
- (5) Remove two short screws (7), two long screws (8), and back cover (9).
- (6) Disconnect modular cord (10) from interface board (11).
- (7) On older units, cut cable tie (12) securing modular cord (10).

On newer units, remove screw (13) securing cable tie (14); then cut cable tie.
- (8) Remove upholstered seat section (1, Figure 2) from seat casting (2).
- (9) Remove three screws (3) and seat cover (4).



- (10) Carefully pry modular cord (5) out of bushing (6).
- (11) Remove two screws (7) securing cable ties (8).
- (12) Remove screw (9) and cable clamp (10).
- (13) Disconnect wire harness (11) from wire harness (12).
- (14) Cut cable tie (1, Figure 3) securing two wires (2) to back actuator (3).
- (15) Tag and disconnect two wires (2) from limit switch (4).
- (16) Loosen set screw (5); then unscrew seat nut (6).
- (17) Remove thrust washer (7), thrust bearing (8), and thrust washer (9) from threaded post of slide weldment (10).





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Figure 4.

- (18) Remove two outside bolts (1, Figure 4) and lockwashers (2).
- (19) Remove two inside bolts (3) and brake assembly (4) from seat casting (5).
- (20) Remove stop (6) from seat casting (5).



CAUTION

Table top is heavy and bulky to lift. Use an assistant and proper lifting techniques to lift the table top. Failure to do could result in injury.

- (21) Lift table top (7) straight up off of slide weldment (8).

B. Replacing Seat Rotation Stop

- (1) Turn table top upside down.
- (2) Remove two screws (1, Figure 5) and old seat rotation stop (2) from seat casting (3).
- (3) Position template (4) so that two holes (A) align with holes used for old seat rotation stop (2); then secure template with two screws (1).
- (4) Using hole (B) of template (4) as a guide, drill a 1/8" pilot hole in seat casting (3).
- (5) Remove two screws (1) and template (4).
- (6) Using 1/8" pilot hole as a guide, drill a 0.257" hole using the "F" size drill bit (*supplied*).
- (7) Use a 5/16"-18 tap to thread 0.257" hole (B) drilled in seat casting (3).
- (8) Install new seat rotation stop (5) and secure with screw (6).



EQUIPMENT ALERT

When drilling or tapping holes in seat casting, use cutting fluid and run drill at its slowest speed. Excessive heat will melt the casting.



EQUIPMENT ALERT

Use cutting fluid and run drill at slowest speed.

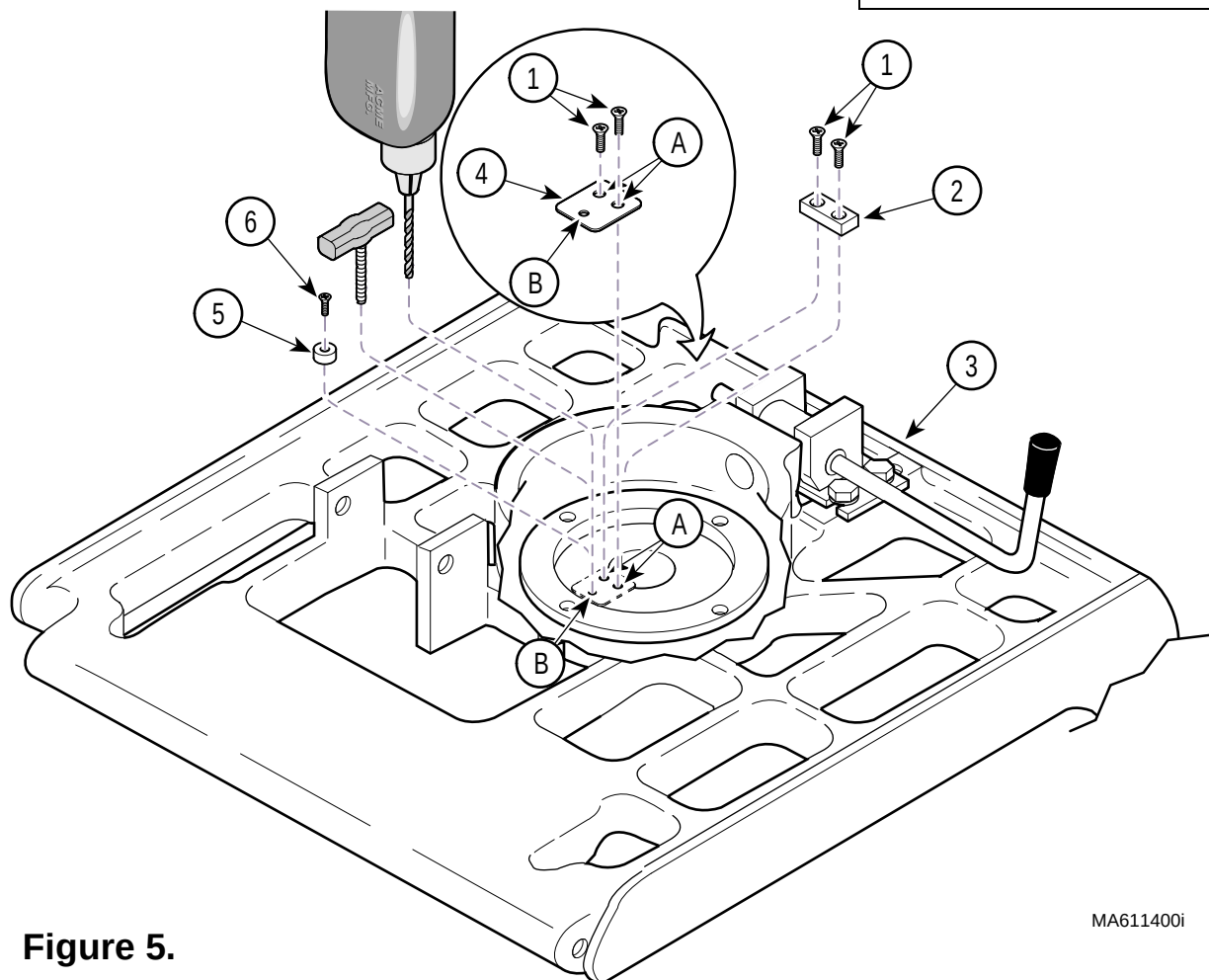


Figure 5.

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C. Installing Table Top

- (1) Coat top surface of slide weldment (8, Figure 6) with Vaseline.



CAUTION

Table top is heavy and bulky to lift. Use an assistant and proper lifting techniques to lift the table top. Failure to do could result in injury.

- (2) Lift table top (7) and position it on slide weldment (8) making sure to route all wires thru center hole of seat casting (5).

- (3) Install stop (6) in seat casting (5), making sure that bevel of stop is in horizontal position.

NOTE

Do not completely tighten bolts. The brake assembly will be adjusted later.

- (4) Install brake assembly (4) on seat casting (5); then secure with two inside bolts (3), two outside bolts (1) and lockwashers (2).

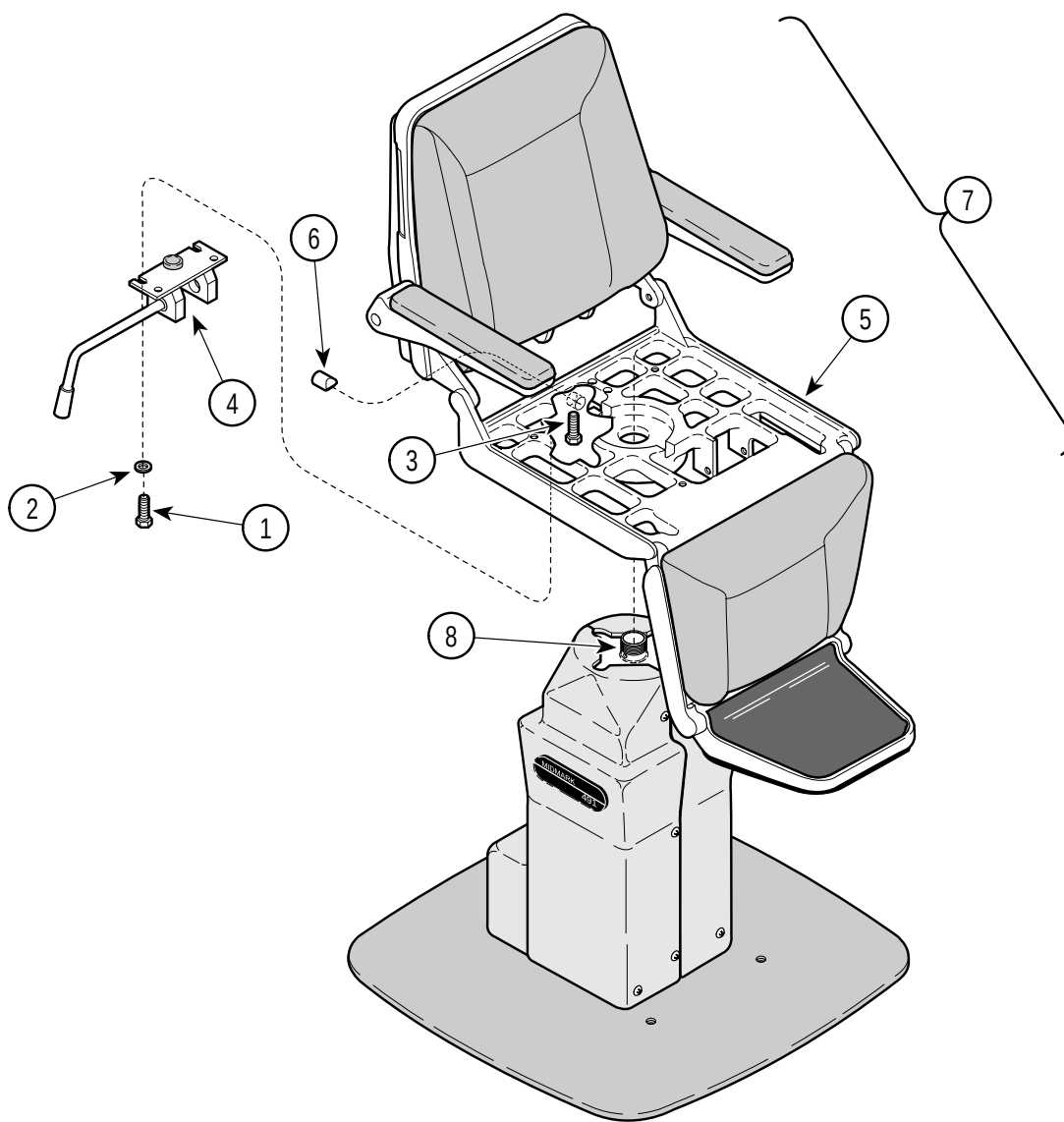


Figure 6.

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- (5) Inspect threads of slide weldment (10, Figure 7). If threads are damaged, use a thread file [20 threads-per-inch] to repair threads.
- (6) Clean thrust washers (7 & 9) and thrust bearing (8) with solvent. Allow to dry.
- (7) Coat threads of slide weldment (10) and seat nut (6) with Vaseline.
- (8) Install thrust washer (9), thrust bearing (8), and thrust washer (7) onto slide weldment (10).

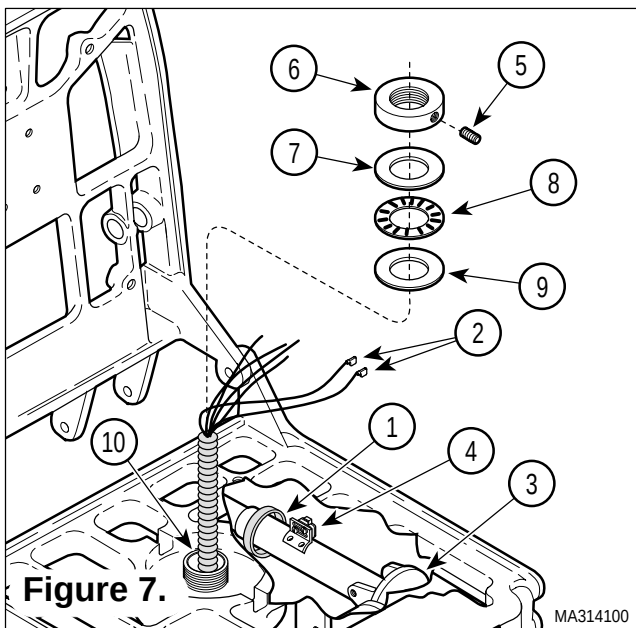


EQUIPMENT ALERT

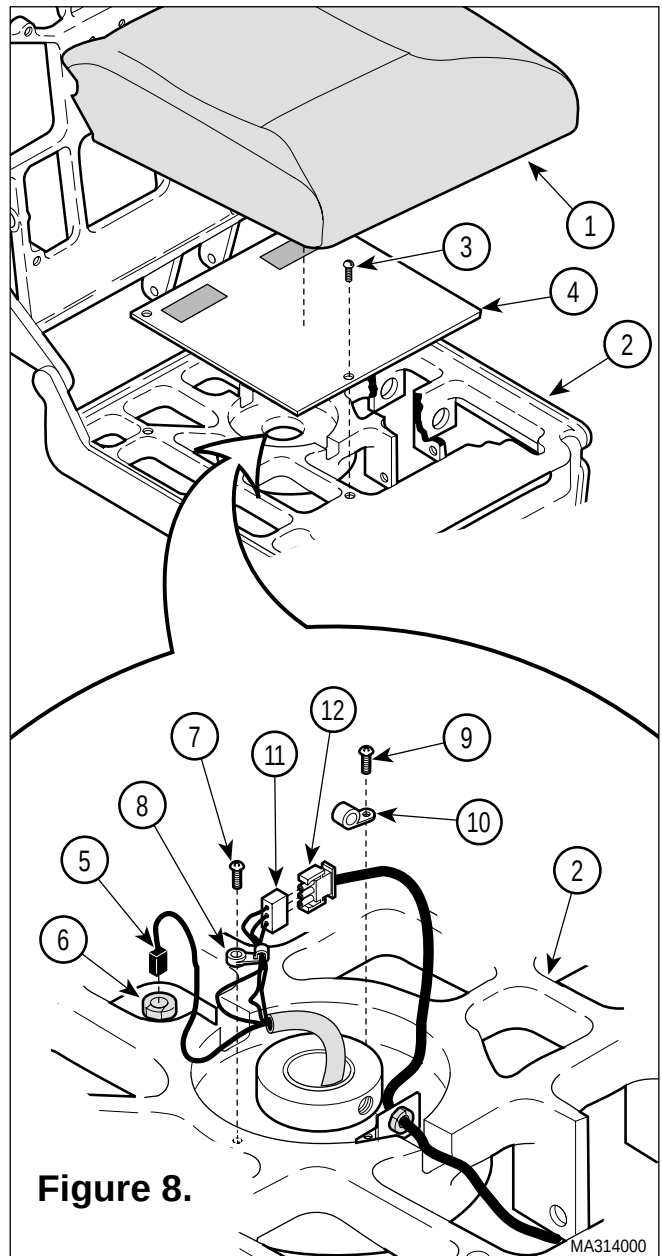
Seat nut (6) should thread easily onto slide weldment (10). Forcing seat nut may result in damage to the fine threads of the slide weldment.

Install seat nut with counterbore facing downward.

- (9) Install seat nut (6) onto slide weldment (10). *[Tighten seat nut until table top is steady when "rocked" from side to side. A slight amount of resistance should be felt when table top is rotated].*
- (10) Tighten set screw (5),
- (11) Connect one wire (2) to COM. terminal, and other wire (2) to N.C. terminal of base up limit switch (4).
- (12) Secure two wires (2) to back actuator (3) with cable tie (1).



- (13) Connect wire harness (11, Figure 8) to wire harness (12).
- (14) Install cable clamp (10) onto wires.
- (15) Secure cable clamp (10) to seat casting (2) with screw (9).
- (16) Secure two cable ties (8) to seat casting (2) with two screws (7).
- (17) Feed modular cable (5) thru bushing (6).
- (18) Install seat cover (4) on seat casting (2) and secure with three screws (3).
- (19) Install seat upholstery (1).



(20) Connect modular cable (10, Figure 9) to interface board (11).

(21) On older units, secure modular cord (10) to back casting (3) with cable tie (12).

On newer units, install cable tie (14) on modular cord (10); then secure cable tie (14) to back casting (3) with screw (13).

(22) Install back cover (9) on back casting (3) and secure with two long screws (8) and two short screws (7). *[Tighten screws until back cover starts to flex].*

(23) If removed, install exam light (5) on light bracket (6) and secure with four screws (4).

(24) Install headrest (2) on back casting (3) and secure with four screws (1).

